



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-3
Job Sheet 167109



Part No: D3319-3

Job Qty: 16 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Hydro One Networks Inc (CHYDR01)

Lake Simcoe Regional Airport RR #2, 224 Line 7, North Oro Station, ON, L0L 2E0 Canada ph:(705) 487-1771

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	16 Ea		10/30/17	0.00	0.00	Start Up Large Fab1	SC
100	Waterjet	16 pcs		10/30/17	0.00	3.74	Waterjet1	SC
120	QC	16 pcs		10/30/17	0.00	0.00	QC8	
140	Brake NC	16 pcs		10/30/17	0.12	1.12	Brake NC 1	
150	QC	16 pcs		10/30/17	0.00	0.00	QC6	
160	Large Fab	16 pcs		10/30/17	0.00	5.10	Large Fab 6	
170	QC	16 pcs		10/30/17	0.00	0.00	QC10	
180	QC	16 pcs		10/30/17	0.00	0.00	QC5	
190	Powdercoat	16 pcs		10/31/17	0.00	0.56	Powdercoat3	
200	QC	16 pcs		10/31/17	0.00	0.00	QC3	
210	Packaging	16 pcs		10/31/17	0.00	0.00	Packaging3	
220	QC21-SA	16 Ea		10/31/17	0.00	0.00	QC21	

Part Op 100 - 1-Cut as per Dwg D3319

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319Rev: _____

160 - Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319

190 - START TIME: _____

210 - Identify on inside surface using a permanent fine point marker with the following:

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M1010S18GA	52	100	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Dev _____ Job No: 167109 Mfg Date: 10/25/17	14 Start up Operation D3319-3	Change No: Quantity: Operation: Revision: PART NO:	Completed By _____
			ad hand / Supervisor approval Verification _____
			C / QA Coordinator Approval _____
			ositioned Wrong outside Dimensions ver/Under tolerance art Incorrect

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressu ☐ Bendin ☐ Centre ☐ Cracks ☐ Crimp/k ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Inspection incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



5	Wearplate	2.940inches ± 0.030	2.970 2.910
6	Wearplate	2.690inches ± 0.030	2.720 2.660
7	Wearplate	3.527inches ± 0.010	3.537 3.517
8	Wearplate	4.520inches ± 0.030	4.550 4.490
9	Wearplate	5.063inches ± 0.010	5.073 5.053
10	Wearplate	6.160inches ± 0.030	6.190 6.130
11	Wearplate	0.600inches ± 0.030	0.630 0.570
12	Wearplate	8.690inches ± 0.010	8.700 8.680
13	Wearplate	30.790inches ± 0.010	30.800 30.780
14	Wearplate	52.880inches ± 0.030	52.910 52.850
15	Wearplate	62.770inches ± 0.010	62.780 62.760
16	Wearplate	74.420inches ± 0.010	74.430 74.410
17	Wearplate	75.520inches ± 0.030	75.550 75.490
18	Wearplate	0.050inches ± 0.010	0.060 0.040

Plex 10/24/17 3:46 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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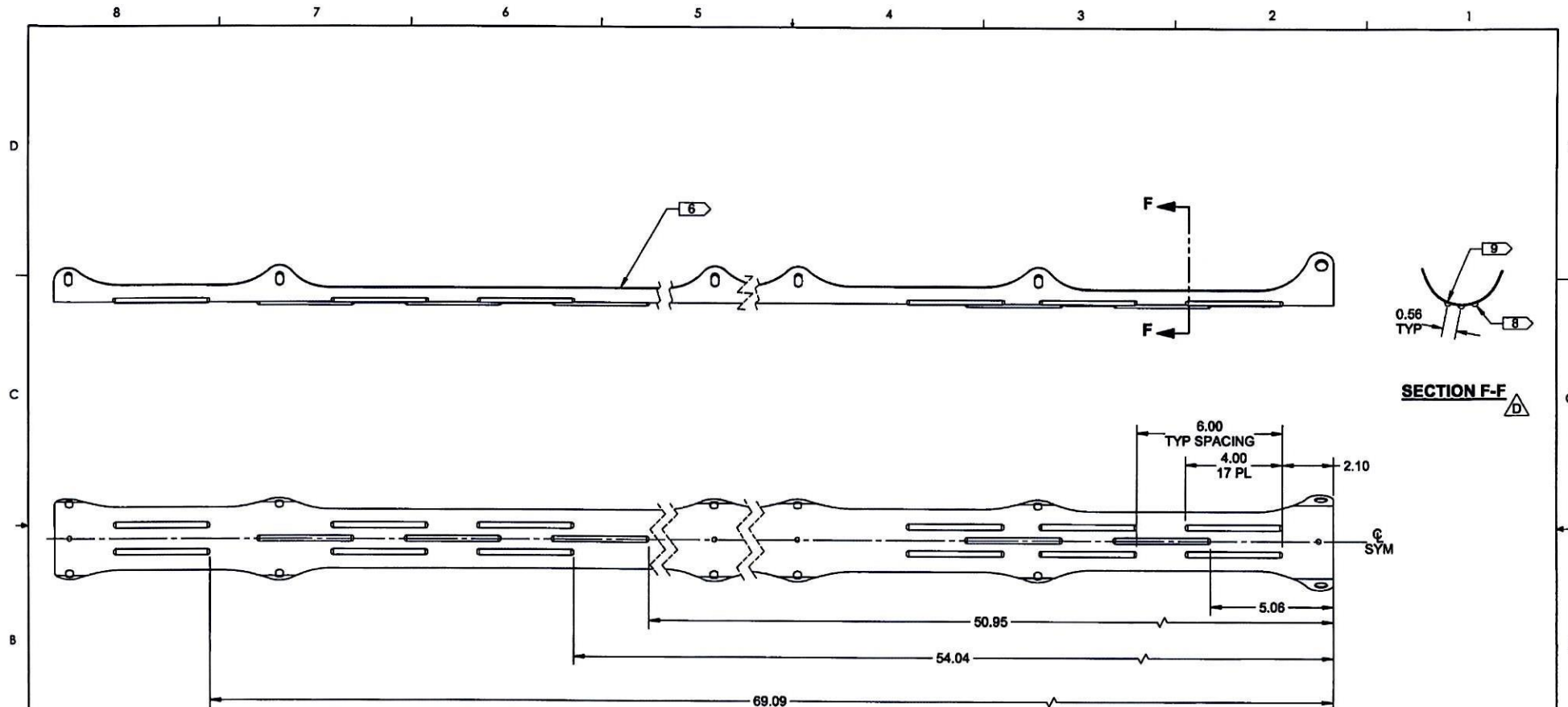
DART AEROSPACE LTD		Work Order: 167109 167109
Description: Wearplate		Part Number: D3319-3
Inspection Dwg: D3319 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø0.191	1		VDC-02	
Ø0.500	+0.006/-0.001	Ø0.500	1		Tape	
0.316	+/-0.010	0.316	1			
0.607	+/-0.010	0.606	1			
2.94	+/-0.030	2.955	1			
2.69	+/-0.030	2.70	1			
3.527	+/-0.010	3.528	1			
4.52	+/-0.030	4.532	1			
5.063	+/-0.010	5.064	1			
6.16	+/-0.030	6.175	1			
0.60	+/-0.030	0.61	1			
8.690	+/-0.010	8.691	1			
30.790	+/-0.010	30.791	1			
52.88	+/-0.030	52.89	1			
62.770	+/-0.010	62.769	1			
74.420	+/-0.010	74.421	1			
75.52	+/-0.030	75.532	1			
0.050	+/-0.010	0.046	1			

Measured by: SC	Audited by:	Preliminary Approval:
Date: 11/10/24	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



SECTION F-F

D3319-3 WEARPLATE
MAKE FROM D3319-3BND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-3" PER QSI 044 6.1
- 7) WEIGHT: 3.71 lbs
- 8) BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

RELEASED

2017 AUG 10

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DP	D3319	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	17.05.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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